



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

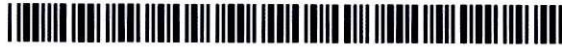
D119-796-241
Job Sheet 180598



Part No: D119-796-241

Job Qty: 1 ea

Part Name: Aft Crosstube Installation Without Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/10/18

Job Tracking No:

Due Date: 8/6/18

Created By: Jesse White

Type: SOLD

Description:

Note: D119-796-241 REV.J IPP REV:A 14.09.03 NEW ISSUE DD VERF:JLM IPP REV:B 14.10.15 AS PER REV.B
DD VERF:JLM IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:D 14.12.12 AS PER REV.pd1 DD
VERF:JLM IPP REV:E 15.02.11 AS PER REV F JLM VERIFIED BY:DD IPP REV:F 17.05.08 AS PER IIN
REV.F DD VERF:JFS

Ship Via:

Bill of Materials



Container No: S092074



Part: D119-796-241

Job No: 180598

Serial No/Batch: S092074

Revision: J

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/16/18

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/6/18	8/6/18	0.00	0.00	Start Up Crosstubes-1		GP 18-07-16
120	Packaging	1 pcs	8/6/18	8/6/18	0.00	0.00	Packaging1-1		GP 18-07-16
130	CNC Bend Crosstubes	1 pcs	8/6/18	8/6/18	4.67	4.17	CNC Bend Crosstube		GP 18-07-16
140	QC	1 pcs	8/6/18	8/6/18	0.00	0.00	QC15		38
145	Crosstubes	1 pcs	8/6/18	8/6/18	0.00	3.30	Crosstubes-1		GP 18-07-16
150	Crosstubes	1 pcs	8/6/18	8/6/18	0.00	3.30	Crosstubes-1		OPZ
160	HandFXtube	1 pcs	8/6/18	8/6/18	0.00	1.28	HandFinish5		OPZ
170	QC	1 pcs	8/6/18	8/6/18	0.00	0.00	QC7-1		38 DAS
175	QC	1 pcs	8/6/18	8/6/18	0.00	0.00	QC5		9-89 38
180	Outsource	1 pcs	8/6/18	8/6/18			SKY002-VC	2	9-89
190	Packaging	1 pcs	8/6/18	8/6/18	0.00	0.00	Packaging2		AUG 14 2018
200	QC	1 pcs	8/6/18	8/6/18	0.00	0.00	QC5		38
230	SprayPaint	1 pcs	8/6/18	8/6/18	0.00	1.31	Spray Paint		SEP 13 2018
240	QC	1 pcs	8/6/18	8/6/18	0.00	0.00	QC14		SEP 13 2018
242	Crosstubes	1 pcs	8/6/18	8/6/18	0.00	3.30	Crosstubes-1		SEP 13 2018
244	QC	1 pcs	8/6/18	8/6/18	0.00	0.00	QC5		SEP 17 2018
246	SprayPaint	1 pcs	8/6/18	8/6/18	0.00	1.31	Spray Paint		SEP 18 2018
248	SprayPaint	1 pcs	8/6/18	8/6/18	0.00	1.31	Spray Paint		SEP 19 2018
250	QC	1 pcs	8/6/18	8/6/18	0.00	0.00	QC14		SEP 19 2018
252	Crosstubes	1 pcs	8/6/18	8/6/18	0.00	3.30	Crosstubes-1		SEP 19 2018
260	QC	1 pcs	8/6/18	8/6/18	0.00	0.00	QC5		SEP 19 2018
270	Packaging	1 pcs	8/6/18	8/6/18	0.00	0.00	Packaging1-1		SEP 19 2018
280	QC	1 pcs	8/6/18	8/6/18	0.00	0.00	QC4		SEP 19 2018
290	Packaging	1 pcs	8/6/18	8/6/18	0.00	0.00	Packaging3-1		SEP 19 2018
295	DC	1 pcs	8/6/18	8/6/18	0.00	0.00	DC		N/R
300	QC21-FG	1 Ea	8/6/18	8/6/18	0.00	0.00	QC21		21

Part Op 130 - Bend tube as per Dwg D119-796-241 using CNC bender program

Descriptions: 145 - 1- CUT TUBE AT HEIGHT ON FAI SHEET

150 - ***** ENSURE PROPER JIG POSITIONING *****

160 - ***IMMEDIATELY AFTER GRINDING***

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

190 - Ensure copy of NDT results attached to work order.

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D119-796-241

230 - ***VERIFY BY _____ BATCH # TO MATCH W/O Primer 138847

240 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

242 - Assemble as per dwg D119-796-241 and QSI 2- Install D5152-043 with proseal 890 on concave surface, 0.100" MIN thick as per dwg using DT10112 (identified right and left) 3- Install center support without boning. 4- Install Damper support and contact pads using proseal 890 per dwg and clamp in position. 138848 exp 11/18

244 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

246 - ***VERIFY BY _____ BATCH # TO MATCH W/O Primer 138877 clump 138832248 - ***VERIFY BY _____ BATCH # TO MATCH W/O Paint 138777

250 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

252 - 1- Re-install non fixed hardware per dwg ***Torque clamps on damper and contact pad to 80-100 IN-LBS.*** 2-

Apply a filet-seal of proseal 890 around damper supports and contact pads. 138848 exp 11/18

260 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED AS PER DWG.*** 1- ATTACH A RED TAG TO CENTER SUPPORT THAT READS CENTER SUPPORT NOT FIXED THEN DATE AND STAMP IT.

290 - Identify and pack for shipping as per PPP D119-796-241

295 - Photocopy bluefile and create labels as per PPP D119-796-241 chg 005

On w/o 180153

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-796-241TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	
CR3212-4-07	Cherry Rivet	16 Ea (16 ea)	230-SprayPaint	
D2873-043	Nut Plate Assembly	4 Ea (4 ea)	230-SprayPaint	
D5122-1	Center Support, Upper	1 Ea (1 ea)	242-Crosstubes	
D5123-1	Clamp Cushion	6 Ea (6 ea)	242-Crosstubes	
D5123-5	Clamp Cushion	2 Ea (2 ea)	242-Crosstubes	
D5134-041	Damper Support Assembly, LH	1 Ea (1 ea)	242-Crosstubes	
D5134-042	Damper Support Assembly, RH	1 Ea (1 ea)	242-Crosstubes	
D5136-1	Contact Pad, LH	1 Ea (1 ea)	242-Crosstubes	
D5136-2	Contact Pad, RH	1 Ea (1 ea)	242-Crosstubes	
D5152-043	Aft Post Mount Assembly	2 Ea (2 ea)	242-Crosstubes	
MS21920-25	Clamp	6 Ea (6 ea)	242-Crosstubes	
MS21920-28	Clamp	2 Ea (2 ea)	252-Crosstubes	
D5515-1	Grounding Clamp	2 Ea (2 ea)	252-Crosstubes	
MS21042L3	Nut	2 Ea (2 ea)	252-Crosstubes	
MS27039-1-08	Screw	2 Ea (2 ea)	252-Crosstubes	
NAS1149D0332J	Washer	4 Ea (4 ea)	252-Crosstubes	
AN174-3A	Bolt	2 Ea (2 ea)	270-Packaging	
MS21042L4	Nut	2 Ea (2 ea)	270-Packaging	
NAS1149D0432J	Washer	4 Ea (4 ea)	270-Packaging	

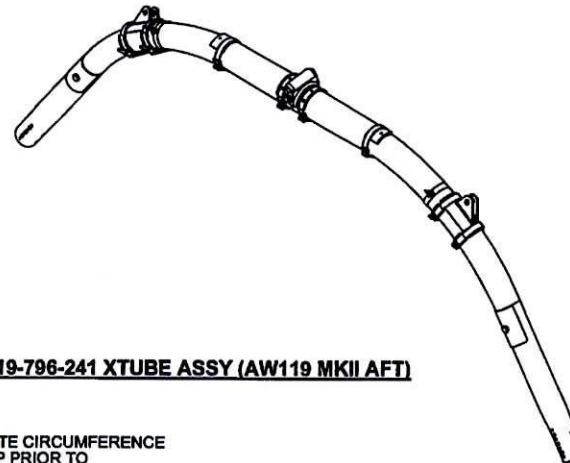
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D119-796-241TRN	1	5	0
230-SprayPaint	CR3212-4-07 M138621-12	16	308	0
	D2873-043 S089003	4	117	0
242-Crosstubes	D5122-1 S090238	1	11	0
	D5123-1 F160081	6	211	0
	D5123-5 163288	2	200	0
	D5134-041 S079482	1	8	0
	D5134-042 S079364	1	6	0
	D5136-1 S082473	1	10	0
	D5136-2 S063066	1	22	0
	D5152-043 S083847	2	18	0
	MS21920-25 S0719113	1	156	0
252-Crosstubes	D5515-1 S0800805	2	26	0
	MS21042L3 S089340	2	2,037	0
	MS21920-28 S060057	2	37	0
	MS27039-1-08 S080600	2	367	0
	NAS1149D0332J S0100407	4	1,505	0
270-Packaging	AN174-3A M138441	2	46	0
	MS21042L4 S094597	2	3,010	0
	NAS1149D0432J S093756	4	166	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Assembly (AW119 MKII Aft)	5.880Inches ± 0.030	5.910 5.850		
2	Crosstube Assembly (AW119 MKII Aft)	2.516Inches $+ 0.005$ $- 0.000$	2.521 2.516		
3	Crosstube Assembly (AW119 MKII Aft)	2.626Inches $+ 0.005$ $- 0.000$	2.631 2.626		
4	Crosstube Assembly (AW119 MKII Aft)	2.627Inches $+ 0.005$ $- 0.000$	2.632 2.627		
5	Crosstube Assembly (AW119 MKII Aft)	2.798Inches $+ 0.005$ $- 0.000$	2.803 2.798		
6	Crosstube Assembly (AW119 MKII Aft)	2.799Inches $+ 0.005$ $- 0.000$	2.804 2.799		
7	Crosstube Assembly (AW119 MKII Aft)	2.989Inches $+ 0.005$ $- 0.000$	2.994 2.989		
8	Crosstube Assembly (AW119 MKII Aft)	3.191Inches $+ 0.005$ $- 0.000$	3.196 3.191		
9	Crosstube Assembly (AW119 MKII Aft)	3.200Inches $+ 0.005$ $- 0.000$	3.205 3.200		
10	Crosstube Assembly (AW119 MKII Aft)	5.880Inches ± 0.030	5.910 5.850		
11	Crosstube Assembly (AW119 MKII Aft)	2.516Inches $+ 0.005$ $- 0.000$	2.521 2.516		
12	Crosstube Assembly (AW119 MKII Aft)	2.626Inches $+ 0.005$ $- 0.000$	2.631 2.626		
13	Crosstube Assembly (AW119 MKII Aft)	2.627Inches $+ 0.005$ $- 0.000$	2.632 2.627		
14	Crosstube Assembly (AW119 MKII Aft)	2.798Inches $+ 0.005$ $- 0.000$	2.803 2.798		
15	Crosstube Assembly (AW119 MKII Aft)	2.799Inches $+ 0.005$ $- 0.000$	2.804 2.799		
16	Crosstube Assembly (AW119 MKII Aft)	2.989Inches $+ 0.005$ $- 0.000$	2.994 2.989		
17	Crosstube Assembly (AW119 MKII Aft)	3.191Inches $+ 0.005$ $- 0.000$	3.196 3.191		
18	Crosstube Assembly (AW119 MKII Aft)	3.200Inches $+ 0.005$ $- 0.000$	3.205 3.200		
19	Crosstube Assembly (AW119 MKII Aft)	105.710Inches ± 0.020	105.730 105.690		

Plex 7/10/18 4:07 PM dart.white.jesse

D119-796-241 XTUBE ASSY (AW119 MKII AFT)



NOTES:

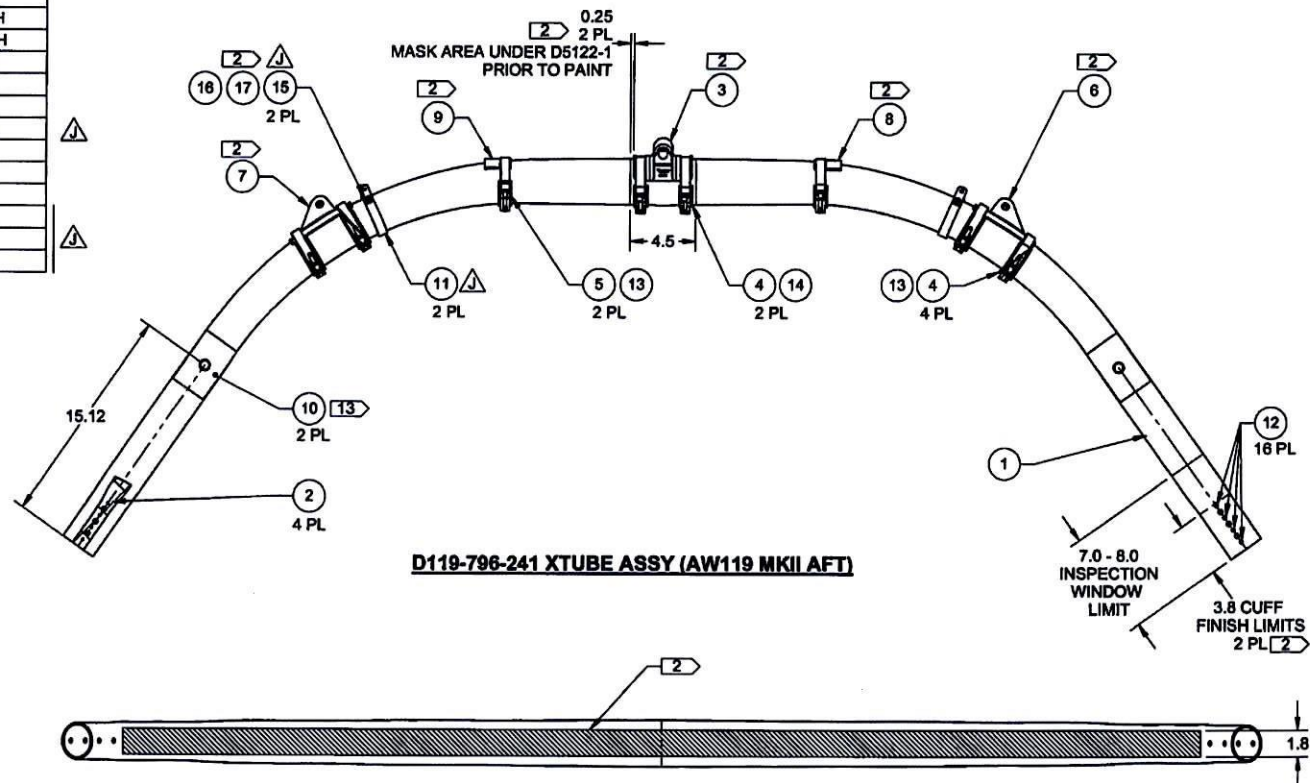
- 1) MATERIAL: N/A
- 2) FINISH: MASK D5134-041/-042 DAMPER SUPPORT ASSEMBLIES, CUFFS, D5136-1/-2 CONTACT PADS, THE COMPLETE CIRCUMFERENCE OF THE TUBE UNDER THE D5122-1 CENTER SUPPORT AND THE TAB ON THE D5515-1 GROUNDING CLAMP PRIOR TO APPLICATION OF CLEAR COAT/PAINT. IF NECESSARY TOUCH UP PRIMER ON OUTSIDE OF CROSSTUBE PER DART QSI 005 4.2. APPLY MATTE CLEAR COAT TO THE UNDERSIDE OF CROSSTUBE AS SHOWN (B4-2, HATCHED AREA) PER QSI 005 4.2. MASK THE UNDERSIDE OF CROSSTUBE AS SHOWN (B4-2, HATCHED AREA). PAINT OUTSIDE PER DART QSI 005 4.2.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY USING PART NUMBER "D119-796-241" AND BATCH NUMBER ON INSIDE OF CUFF PER QSI 044 6.4
- 7) WEIGHT: 28.26 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM DEFECTS SUCH AS SCRATCHES, NICKS OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) INSTALL D5122-1 CENTER SUPPORT HAND TIGHT ONLY. DO NOT TORQUE. INSTALL RED TAG TO INDICATE "D5122-1 CENTER SUPPORT MUST BE BONDED PER IIN-D119-796 PRIOR TO FLIGHT".
- 10) PRIOR TO FINISHING, ABRASE MATING SURFACES OF D5136-1/-2 AND SURFACE OF CROSSTUBE WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. APPLY A 0.100" MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5136-1/-2 CONTACT PADS AND INSTALL AT AN 8.4" OFFSET FROM THE CROSSTUBE BENDING PLANE. INSTALL MS21920-25 CLAMPS AND D5123-5 CLAMP CUSHIONS WHILE WET. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- 11) TORQUE MS21920 CLAMPS 80 - 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY, THE NUT HAS NOT BOTTOMED-OUT AFTER TORQUING AND THE NUT IS FACING AFT.
- 12) PRIOR TO FINISHING, POSITION AND INSTALL D5134-041/-042 DAMPER SUPPORTS USING JIG DT10085. ABRASE MATING SURFACES OF THE D5134-041/-042 DAMPER SUPPORTS AND CROSSTUBE WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. APPLY A 0.100" MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5134-041/-042. INSTALL MS21920-25 CLAMPS AND D5123-1 CLAMP CUSHIONS WHILE WET. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS. ENSURE THAT THE MS21920 CLAMPS ARE POSITIONED AS SHOWN IN DETAIL C.
- 13) PRIOR TO FINISHING, ABRASE MATING SURFACES OF CROSSTUBE AND D5152-043 WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. INSTALL D5152-043 WITH LAYER OF PROSEAL 890 ON INSIDE CONCAVE SURFACE, 0.100" MIN THK LOCATE D5152-043 USING TOOL DT10112.
- 14) INSTALL THE D5515-1 GROUNDING CLAMP AND ASSOCIATED HARDWARE PER DETAIL "C" PRIOR TO FINISHING. TORQUE THE MS21042-3 NUT 12-15 IN-LB. COMPLETELY SEAL THE CLAMP USING PROSEAL 890.
- 15) CARRY OUT A RESISTANCE CHECK BETWEEN THE D5515-1 GROUNDING CLAMP AND ANY UNPAINTED SECTION OF THE CROSSTUBE IN ACCORDANCE WITH AC43-13-1B CHAPTER 11. MAXIMUM RESISTANCE IS 3 MEGOHMS.

J	ADD NOTE 14 & 15 ON SHT 1, ADD PAINT/PRIMER MASKING LOCATIONS, REVISE NOTES ON SHT 1 & 4, REVISE BOM ON SHT 2 TO ADD GROUNDING CLAMP AND ASSOCIATED HARDWARE. REF PAR 17-580	ML	17.02.10
I	D6023-106 MATERIAL REPLACES D6009-106, D5136-1/-2 & D5134-041/-042 NOW INSTALLED ON PRIMER	AP	15.10.13
H	NOTE 9 RE-WRITTEN, BONDING INSTRUCTIONS MOVED TO IIN. SEE PREVIOUS REV FOR DETAILS.	AP	15.07.02
G	FINISHING ORDER ADJUSTED, UPDATE BEND TOLERANCE AND TRN DETAIL TOLERANCE TO MATCH D119-796-141 DWG	AP	15.04.24
F	REMOVED PRIMER/PAINT ON CUFFS, 2.516 WAS 2.500 (C8-5)	AP	15.02.03
E	D5152-043 WAS D5150-3, SCOTCH BRITE 7447 RED WAS 180 GRIT SANDPAPER	DB	15.01.15
D	ADD D5150-3 STEP POST (2X), MOVED INSPECTION WINDOW DETAIL TO SHT 1, MODIFIED NOTES ON SH 1 & 3	DB	14.11.25
C	CR3212-4-07 RIVETS WAS CR3212-4-05 RIVETS, RADIUS BLOCK WAS NUT PLATE ASSEMBLY (BOM), REMOVED 7.5 DEG CUFF HOLE OFFSET (A1-S), REDUCED CUFF DIA TO 2.500 (C8-5), ADD INSPECTION WINDOW	AP	14.10.23
B	ORIENTATION OF D5122-1 CENTER SUPPORT WAS CORRECTED, D5123-5 ADDED UNDER D5136-1/-2 CONTACT PADS, ADDED D2873-043 NUT PLATE ASSY & CR3212-4-05 RIVETS, ADDED REFERENCE TO SKIDTUBES FOR LOCATING CUFF HOLES, RE-ORGANIZED NOTES, REMOVED REDUNDANT INFORMATION.	AP	14.09.08
A	NEW ISSUE	AP	14.08.07
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	JMH	DRAWING NO.	REV. J
MFG. APPR.	DP	D119-796-241	SHEET 1 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
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2017-05-04
ECN 17-536

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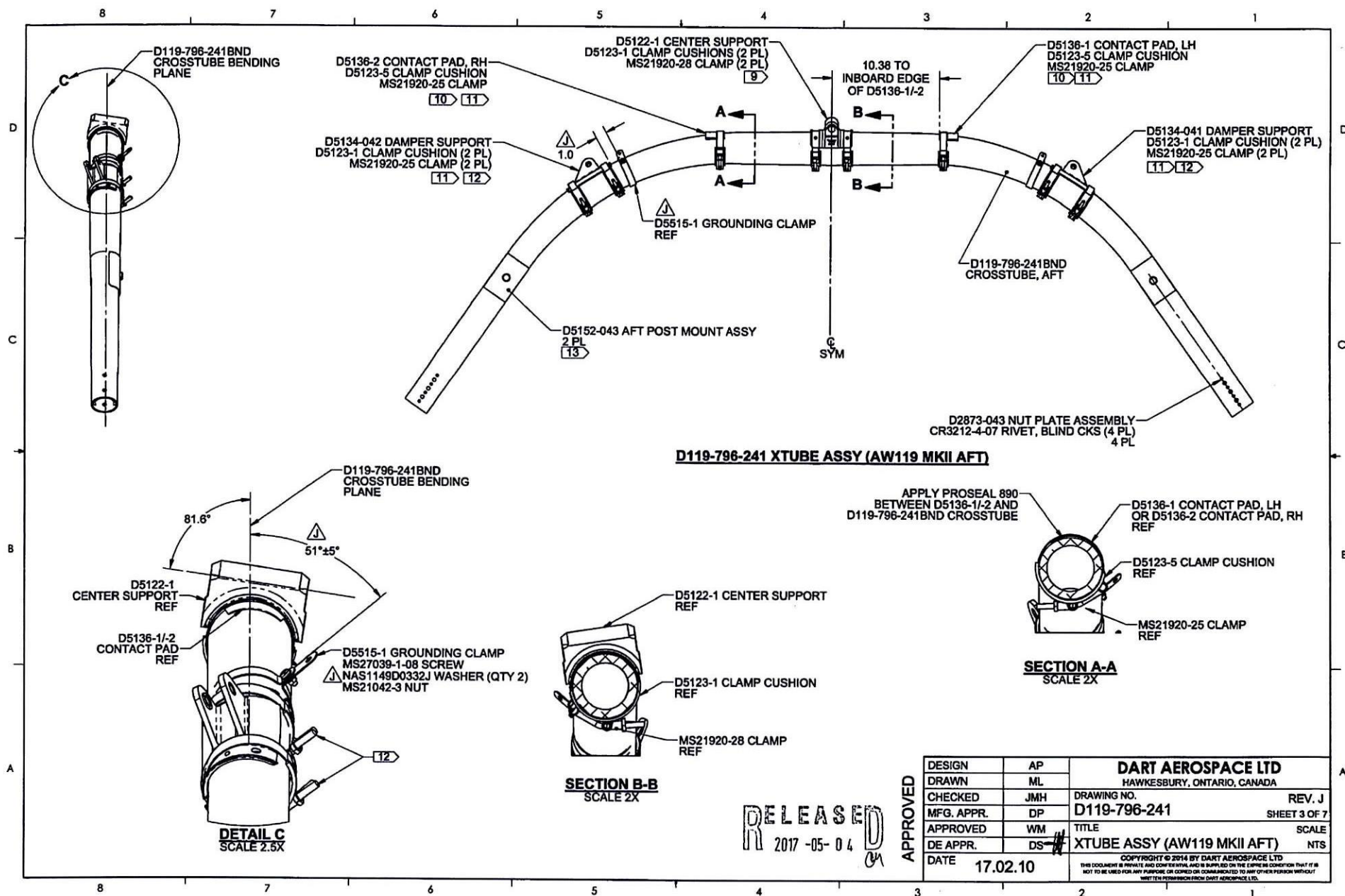
ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241BND	CROSSTUBE, AFT
2	4	D2873-043	RADIUS BLOCK
3	1	D5122-1	CENTER SUPPORT
4	6	D5123-1	CLAMP CUSHION
5	2	D5123-5	CLAMP CUSHION
6	1	D5134-041	DAMPER SUPPORT ASSY, LH
7	1	D5134-042	DAMPER SUPPORT ASSY, RH
8	1	D5136-1	CONTACT PAD, LH
9	1	D5136-2	CONTACT PAD, RH
10	2	D5152-043	AFT POST MOUNT ASSY
11	2	D5515-1	GROUNDING CLAMP
12	16	CR3212-4-07	CSK RIVET, CHERRY MAX
13	6	MS21920-25	CLAMP
14	2	MS21920-28	CLAMP
15	2	MS27039-1-08	SCREW, PAN-HEAD
16	2	MS21042-3	NUT
17	4	NAS1149D0332J	WASHER



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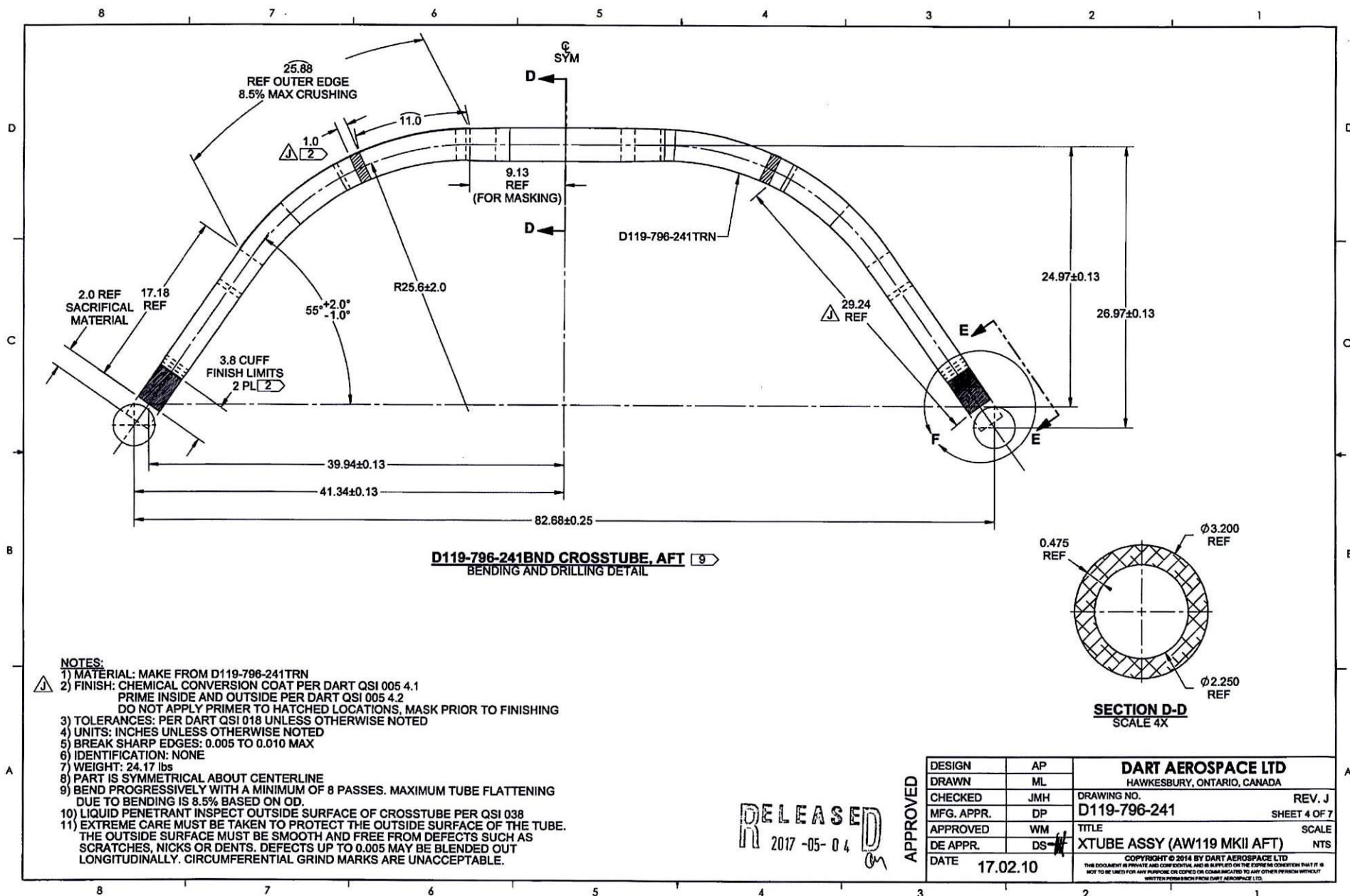
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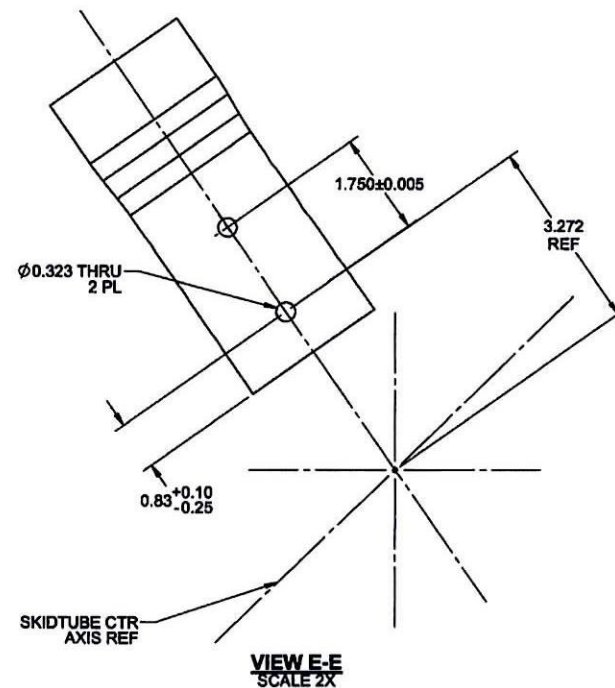
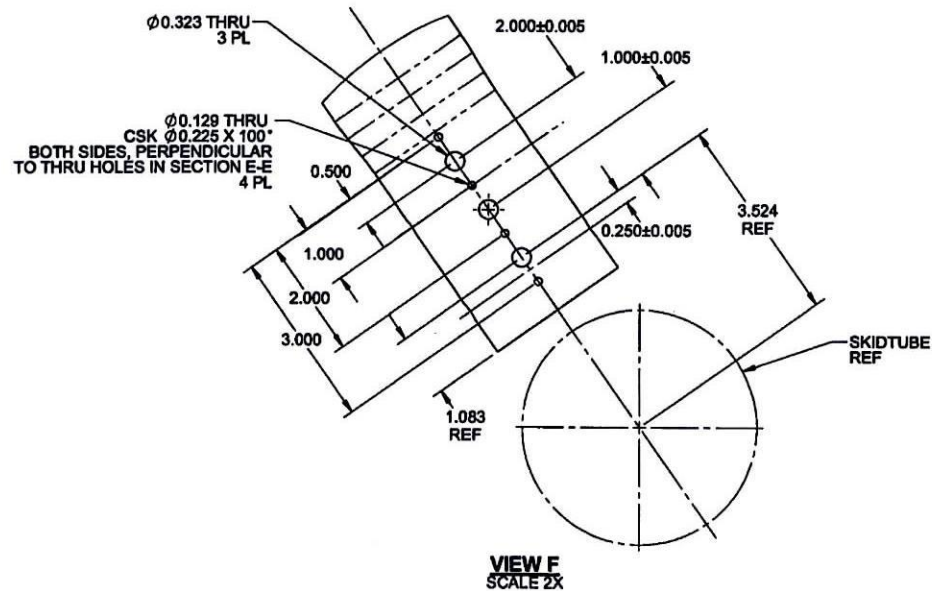
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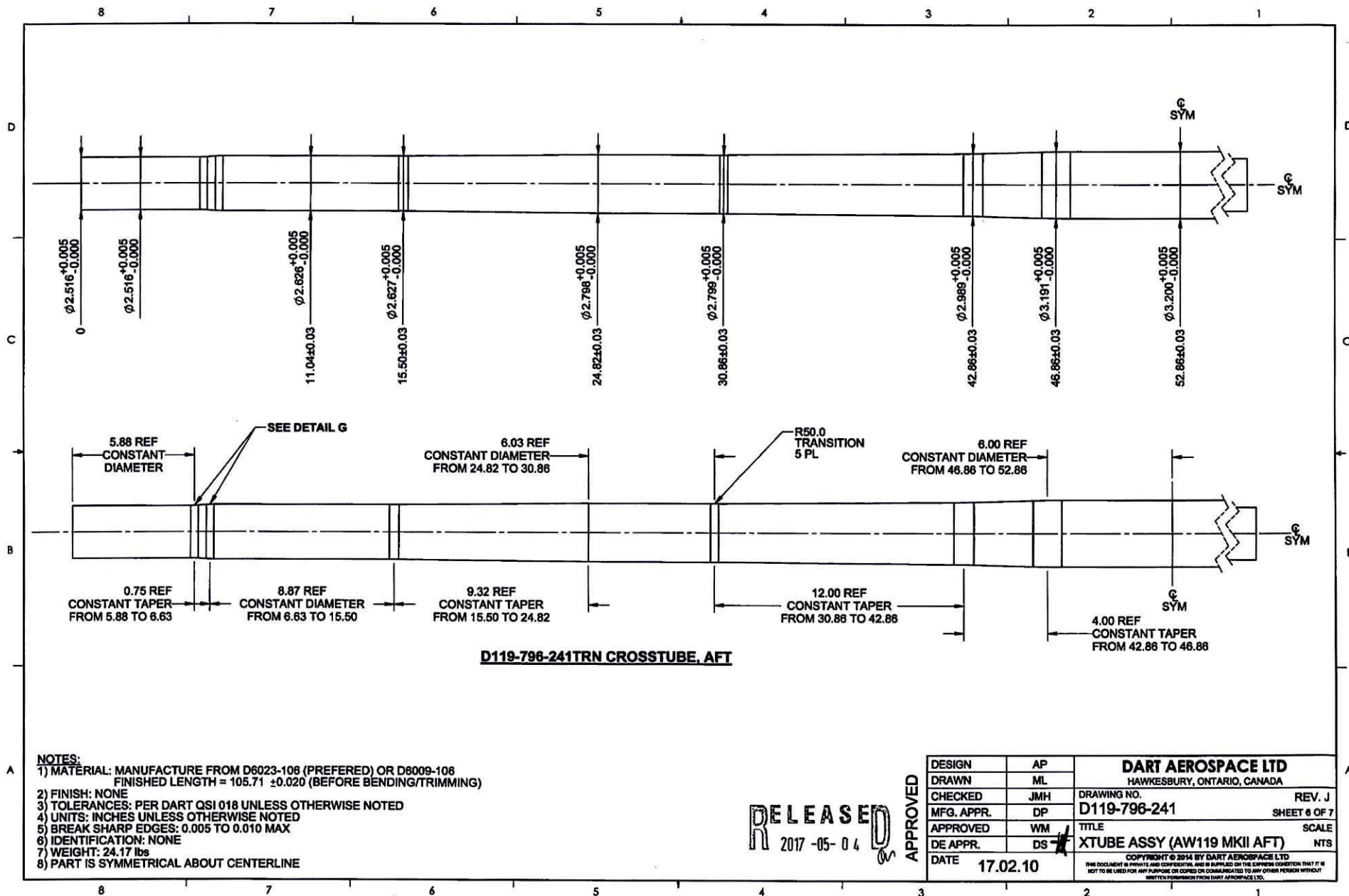
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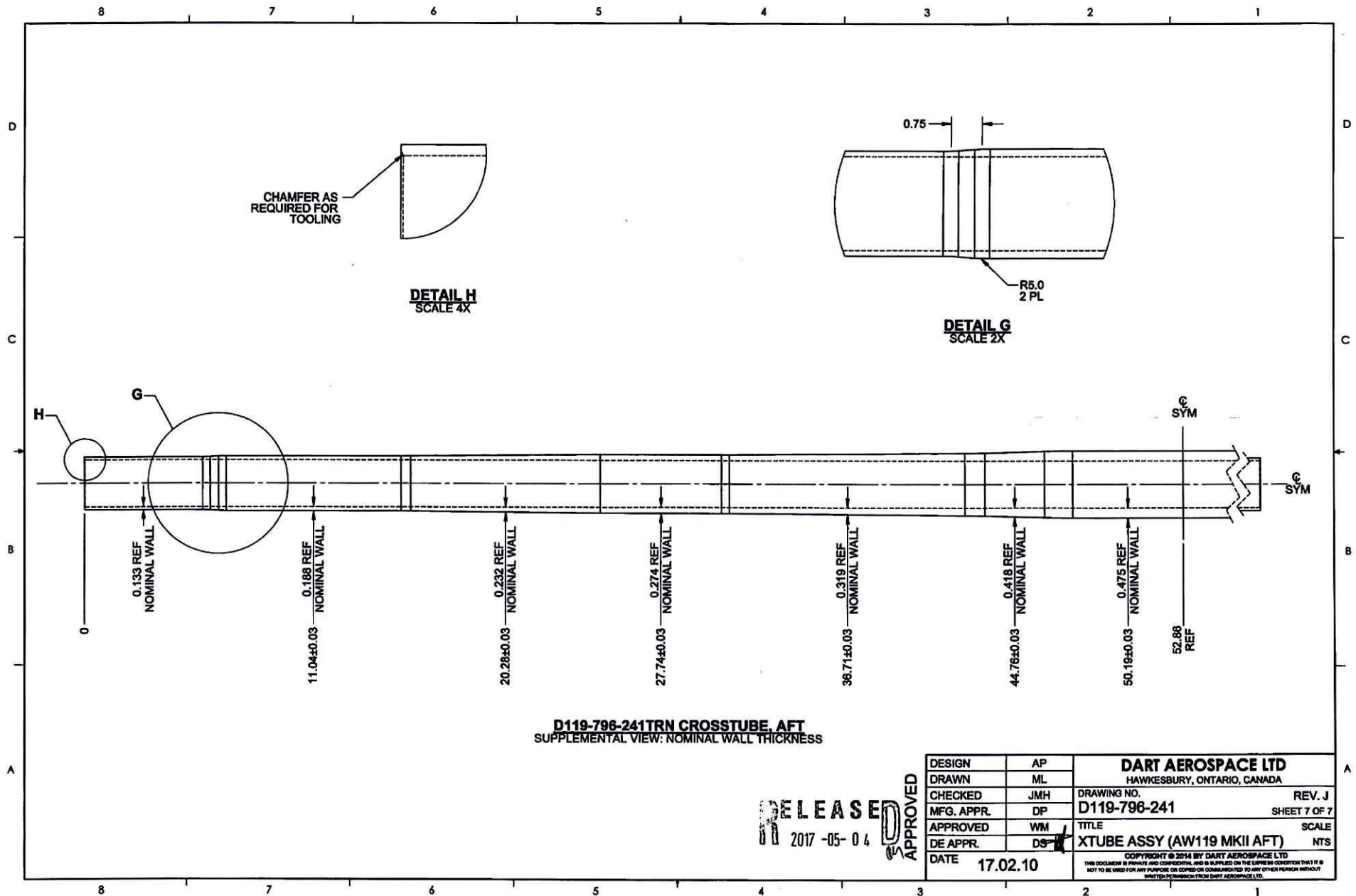


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2017-05-04

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MFG. APPR.	DP	D119-796-241	SHEET 5 OF 7
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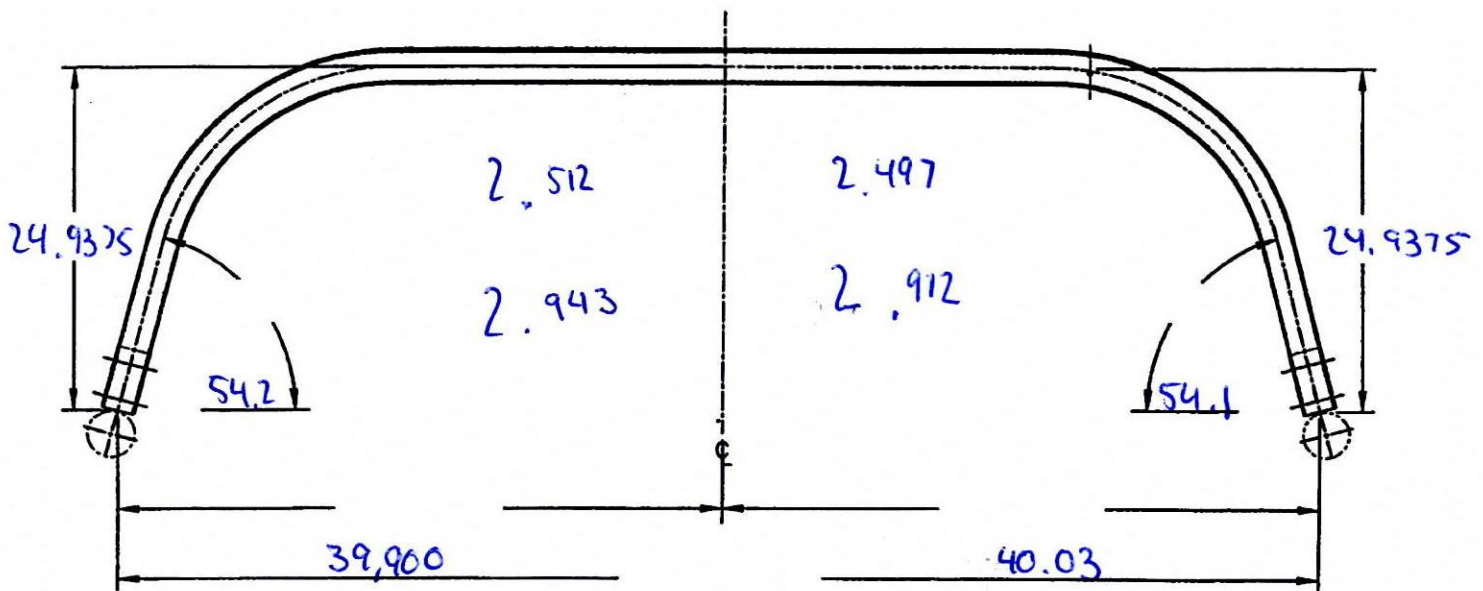
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DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. J
MFG. APPR.	DP	D119-796-241	SHEET 7 OF 7
APPROVED	WM	TITLE	SCALE
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DATE	17.02.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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SH_ShipToName	Cases Involving 20326	Recommended Contact	Position	Telephone	Email	ops
CASCADE HELICOPTER SERVICES	none	Justin Heater	DOM	(206) 767-5290	justin@cascadeheliservices.com	operator
COASTAL HELICOPTERS INC	Case 10179 (December 2017, 20326-1400 s/n 004, Inlet check valve issue, Repaired by Dart)	Mark Johnson	DOM	(907) 789-5600	mjohnson@coastalhelicopters.com	operator
EASTWAY AVIATION D.B.A SUNRISE JETS	None	Eric Lang	President	(631) 737-9911	elang@sunrisejets.com	operator
ERA HELICOPTERS	Case 10326 (March 2018, unserviceable 20707 step) Case 10261 (February 2018, 20326-900 missing part)	Ben Hulshoff	DOM	(337) 312 2280	bhulshoff@erahelicopters.com	operator
HELICOPTER FLIGHT SERVICES	None	Mike Dillon	DOM	(908) 474 0701	mdillon@heliny.com	operator
PORT CITY AIR - NHH (NEW HAMPSHIRE HELICOPTERS INC)	Case 9313 (March 2016, float attachment float mls-drilled)	Steve Fox	DOM	(603) 766-3265	sfox@portcityair.com	operator
NORTHERN PIONEER HELICOPTERS	None Case 9588 (November 2016, non-conforming covers ordered as spares)	Matt Biloff	DOM	(907) 892 1303	nph@mtaonline.net	operator
PRECISION SUPPORT SERVICES LLC	Case 8665 (January 2015, 20326-1300 received with parts missing and incorrect parts) Case 8659 (January 2015, part out of tolerance)	Allison Plummer	Program Manager	(503) 537-0108	allison@flyprecision.com	operator
ROBERTS AIRCRAFT	None	Dennis Pedersen	Logistics/Operations	(307) 778-5700	dpedersen@transaerohehl.com	operator
TEMSCO HELICOPTERS	Case 9720 (March 2017, complaints about hose lengths and float attachment hardware) Case 7220 (May 2013, request reservoir alternate location)	Roy Hornbaker	DOM	(907) 225 5141	roy_hornbaker@temscosair.com	operator
TEX-AIR HELICOPTERS INC.	None	German Chew		(817) 624 6491	germanc@texairinternational.com	operator
VERTICAL AVIATION	None	Pedro Cruz Roman	Logistics Support	(480) 998 1115	pedro@verticalaviationllc.com	operator

DART AEROSPACE LTD	Work Order:	
Description: Crosstube Aft, with Step	Part Number:	D119-796-241
Inspection Dwg: D119-796-241	Rev: J	Page 1 of 1

Required Dimension	Min	Max
Height	24.840	25.100
1/2 Span	39.810	40.070
Angle	54°	57°
Total Span	79.620	80.140
Bending Passes	8	--
Crushing	--	8.5%



	Side A	Side B
Bending Passes	10	10
Crushing	7.7%	7.7%
Comments		

QC15 Inspection	EB
Date	18-07-12

Rev	Date	Change	Revised by	Approved
A	15.04.14	New Issue	KJ	
B	15.11.12	Min angle revised	KJ	
C	15.12.15	Dwg Rev updated	KJ	
D	17.07.12	Dwg Rev updated	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040713

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO040713
PO Date: 8/9/18
Due Date: 8/13/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180150	D119-796-241	Aft Crosstube Installation Without Step (No Hardware) : TC STC SH14-45-Issue 1, FAA STC SR03504NY 15/01/28, EASA STC 10052022 Revision 1 15/02/13, DGCA INDIA LoA 07-09/2011-AED (Part) 15/07/16, BRAZIL STC 2015S07-16 15/07/30, CAAP PHILIPPINES LoA 16/05/11, CHINA VSTC0757 16/07/22, RUSSIA STC CT316-A119 16/08/11, DGAC INDONESIA STC SR025 18/02/19 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	8/13/18	1 pcs	0 pcs	1 pcs	\$108.1818/pcs	\$108.18
	180154		1 X AUG 14 2018	Firmed	-	8/13/18	1 pcs	0 pcs	1 pcs	\$108.1818/pcs	\$108.18
	180597		1 X AUG 14 2018	Firmed	-	8/13/18	1 pcs	0 pcs	1 pcs	\$108.1818/pcs	\$108.18
	180598		1 X AUG 14 2018	Firmed	-	8/13/18	1 pcs	0 pcs	1 pcs	\$108.1818/pcs	\$108.18
Sub Total:							4	0	4		\$432.73
2	180616	D4464-041	Fuel Tank Assembly : Various STC's ISSUE P/O : LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	8/13/18	1 pcs	0 pcs	1 pcs	\$108.1818/pcs	\$108.18
	180543	D4880-1	Strut : Various STC's	Firmed	-	8/13/18	6 pcs	0 pcs	6 pcs	\$108.1818/pcs	\$649.09
Grand Total:											\$1,190.00



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER
PO040713

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/14/18 11:24 AM dart.baker.diane



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO37008	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO040713
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

1 FUEL TANK ASSY, P/N# D4464-041 , J/S# 180616

6 STRUT, P/N# D4880-1 , J/S# 180543

4 AFT CROSSTUBES, P/N# D119-796-241 , J/S# 180150, 180154, 180597, 180598

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16 CRACK FOUND ON 1 STRUT 3 LEAKS FOUND ON FUEL TANK ASSY CRACK INDICATION FOUND ON 1 CROSSTUBE J/S# 180154 PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142						AUG 10 2018	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		AUG 10 2018